

Date: Monday, 25/09/2006 11:11:52 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PANEL	
Job Number	: 28627		Part Number	: D33307	
Estimate Number	: 10908		Drawing Number	: D3330 REV B1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 25/09/2006	S.O. No. : N/A	Drawing Revision	: B1	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 05/10/2006 Qty: 8 Um: Each	
Previous Run	: 28627				
Written By					
Checked & Approved By					
Comment	: Est. A05.01.13 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-25 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125 Comment: Qty.: 0.7971 sf(s)/Unit Total : 6.3768 sf(s) 1010-1025 sheet .125 Batch: M102247 M 08/10/04
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3330 Dwg Rev: B1 M 08/10/04 Prog Rev: B1 ⑧
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE M 08/10/04 ⑧
4.0	QC8	SECOND CHECK Comment: SECOND CHECK J 08/10/04 B ⑧ PTO
5.0	BRAKE NC	NC BRAKE Comment: NC BRAKE Deburr M 08/10/04 ⑧ Form as per Dwg D3330 SDB 06/10/25 ⑧

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/10/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-04	2.0	Hole is part was not made oblong at Ø.698 at 1.705. 1.605 location.	<i>AB</i> 02/10/04	Fix the DXF to complete oblong hole.	<i>AB</i> 06-10-23	<i>AB</i> 06-10-23	<i>AB</i> 06-10-04	<i>AB</i> 06-10-04
06-10-04	2.0	" Hole was milled to .750.	<i>AB</i> 02/10/04	Mill hole to correct size as per Dwg. acceptable.	<i>AB</i> 06-10-20	<i>AB</i> 06-10-20	<i>AB</i> 06-10-04	<i>AB</i> 06-10-04

NOTE: Date & initial all entries

Date: Monday, 25/09/2006 11:11:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 28627

Part Number: D33307

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



206-10-25



Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS23

CPL 06-10-26

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DO 6/10/26

Job Completion

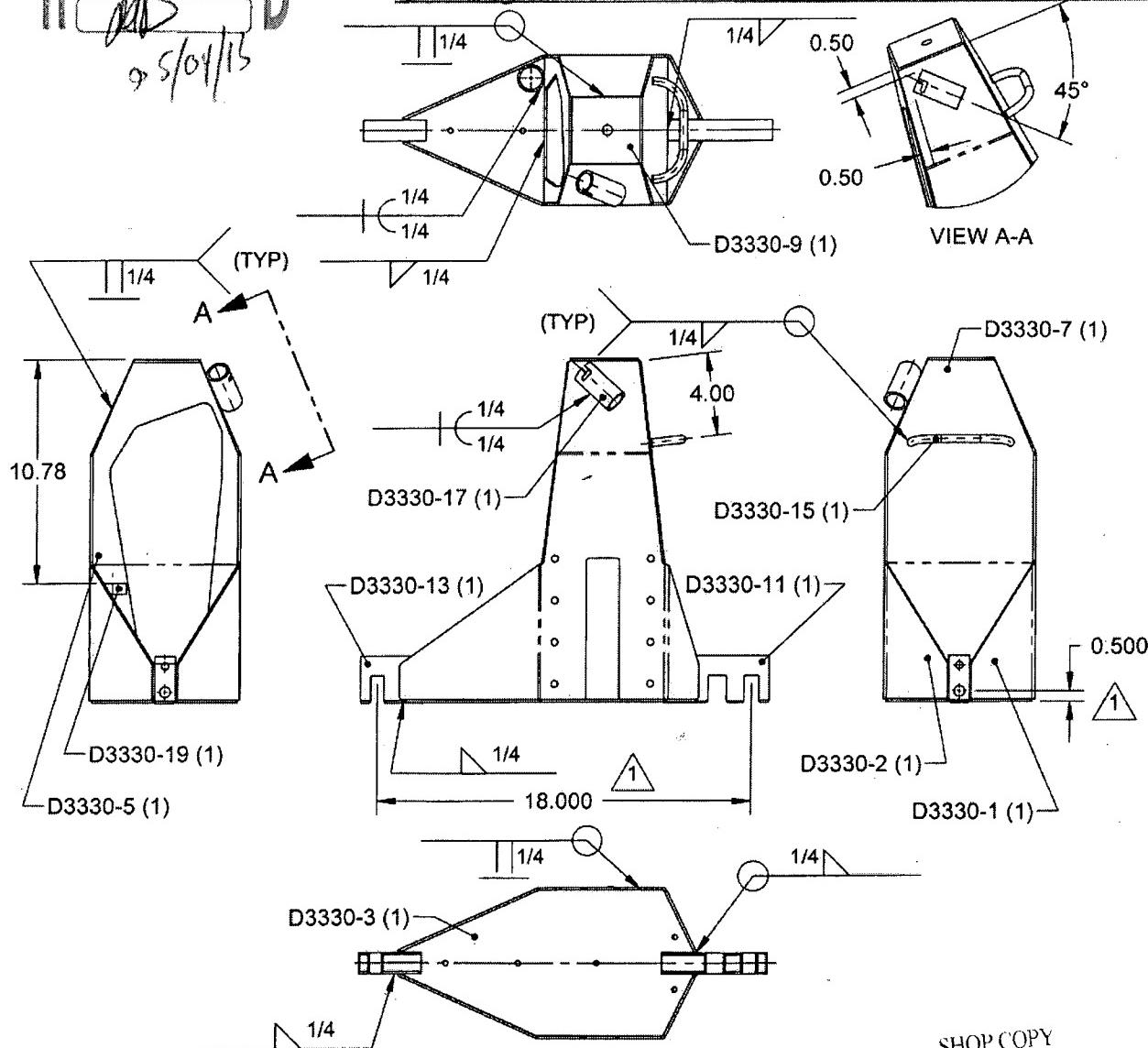


U 06/10/26

DART

DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PF</i>	APPROVED <i>BS</i>	DRAWING NO. D3330	REV. B SHEET 1 OF 9
DATE 05.02.26	TITLE FRAME WELDMENT	SCALE 1:8	
A • 04.12.16	NEW ISSUE		
B 05.02.26	REDESIGN		
B1 05.07.04	ADD 1.605 DIM.		

RELEASED
S/04/15



D3330-041 FRAME WELDMENT

NOTES:

1) POSITION PARTS AS PER JIG D3330-041T1

2) WELD PER QSI 004

3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

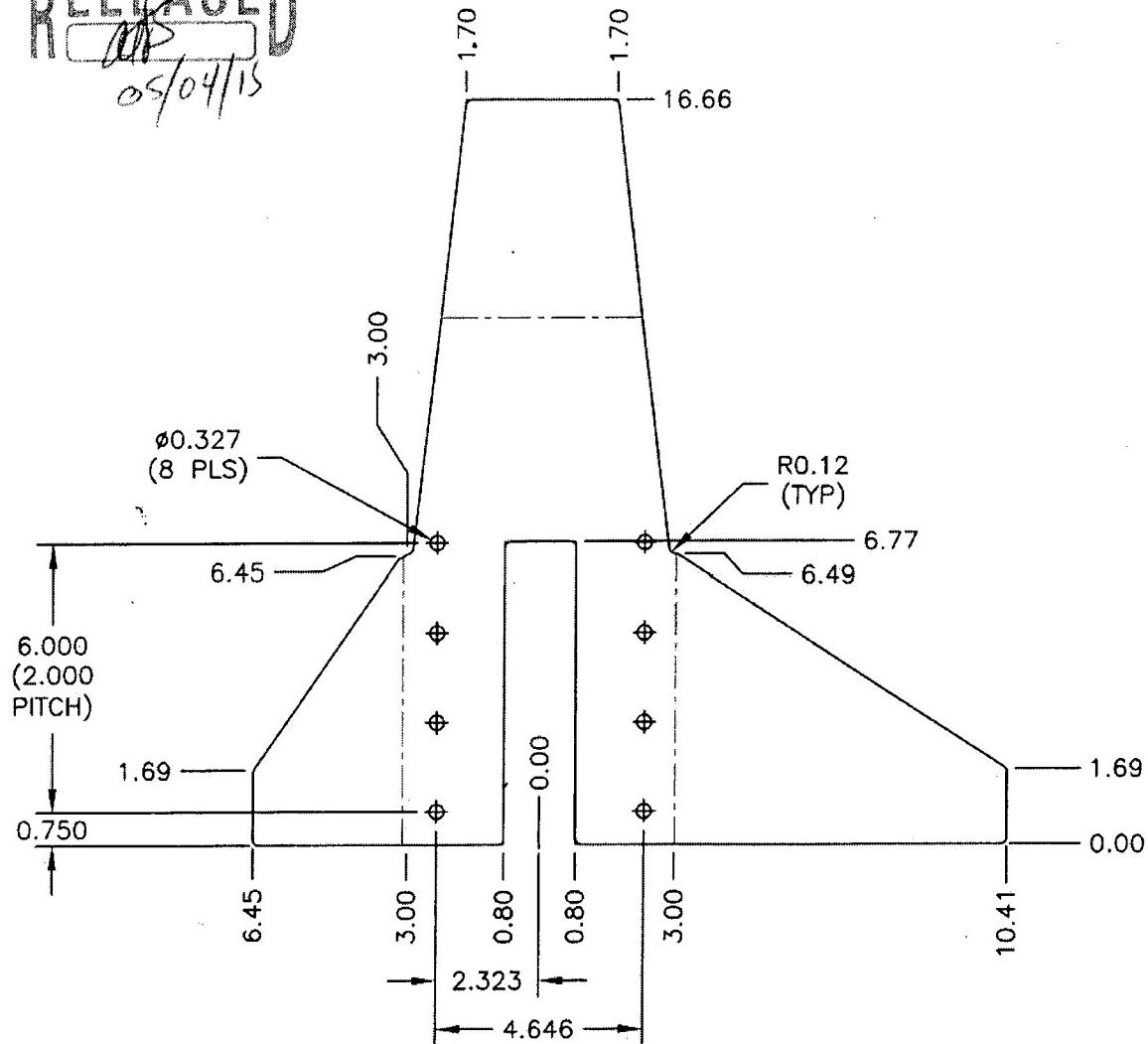
6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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WORK ORDER
NO. *28627*



DESIGN <i>J</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>F</i>	APPROVED <i>OB</i>	DRAWING NO. D3330	REV. B	SHEET 2 OF 9
DATE 05.02.26	TITLE FRAME WELDMENT		SCALE 1:4	

RELEASED
05/04/15



D3330-1 PANEL

NOTES:

- 1)) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, ENGINEERING
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) CONTROLLED COPY
2)) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
3)) ALL DIMENSIONS ARE INCHES WITHOUT NOTICE
4)) BREAK ALL SHARP EDGES 0.005 TO 0.010 WORK ORDER

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BY THE AMENDMENT

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NOTICE

WITHOUT NOTICE

WORK ORDER

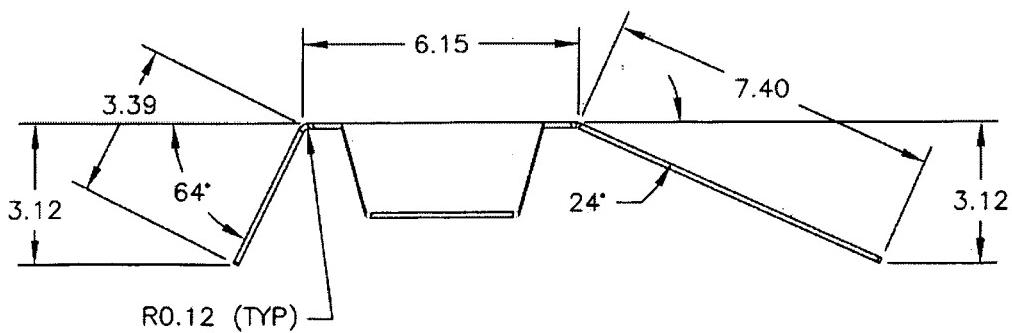
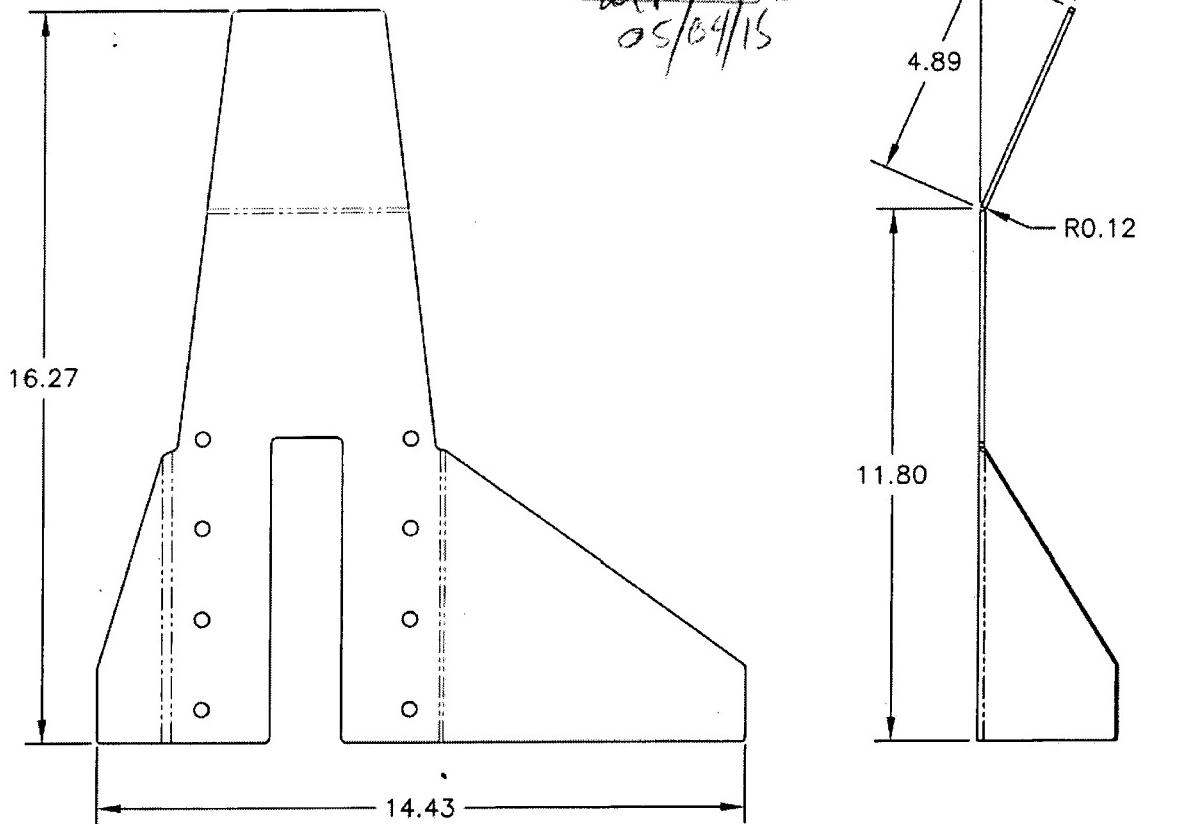
NO 78621

DART

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		D3330	SHEET 3 OF 9
DATE		TITLE	SCALE
05.02.26		FRAME WELDMENT	1:4

RELEASED

05/04/15



D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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WORK ORDER
NO. 28621

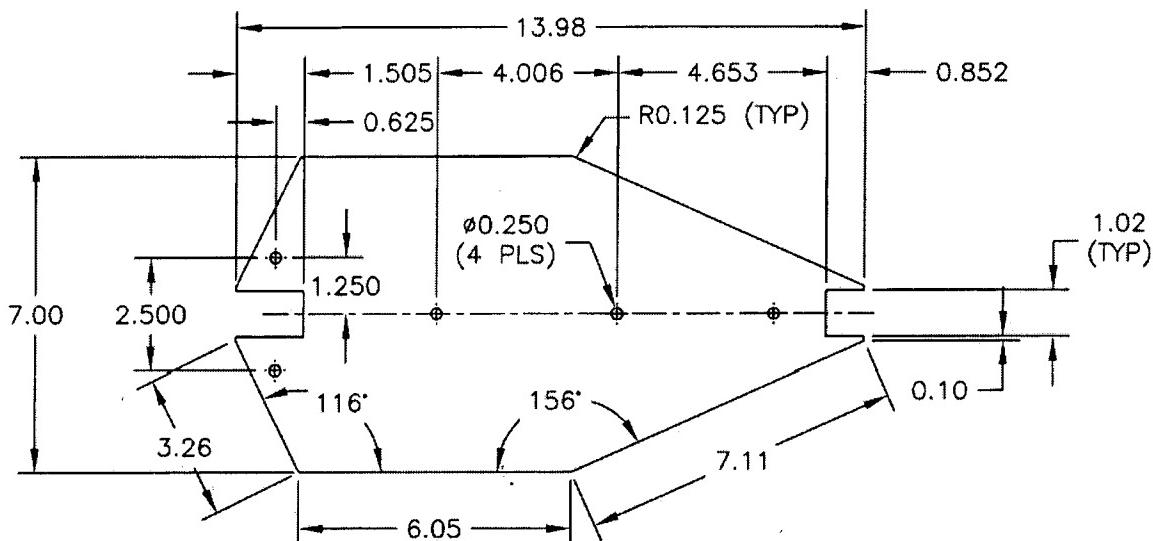
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DATE	05.02.26	D3330	SHEET 4 OF 9

RELEASED
05/04/15

**D3330-3 PLATE**NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) TO AMENDMENT 21, CONTROLLED COPY
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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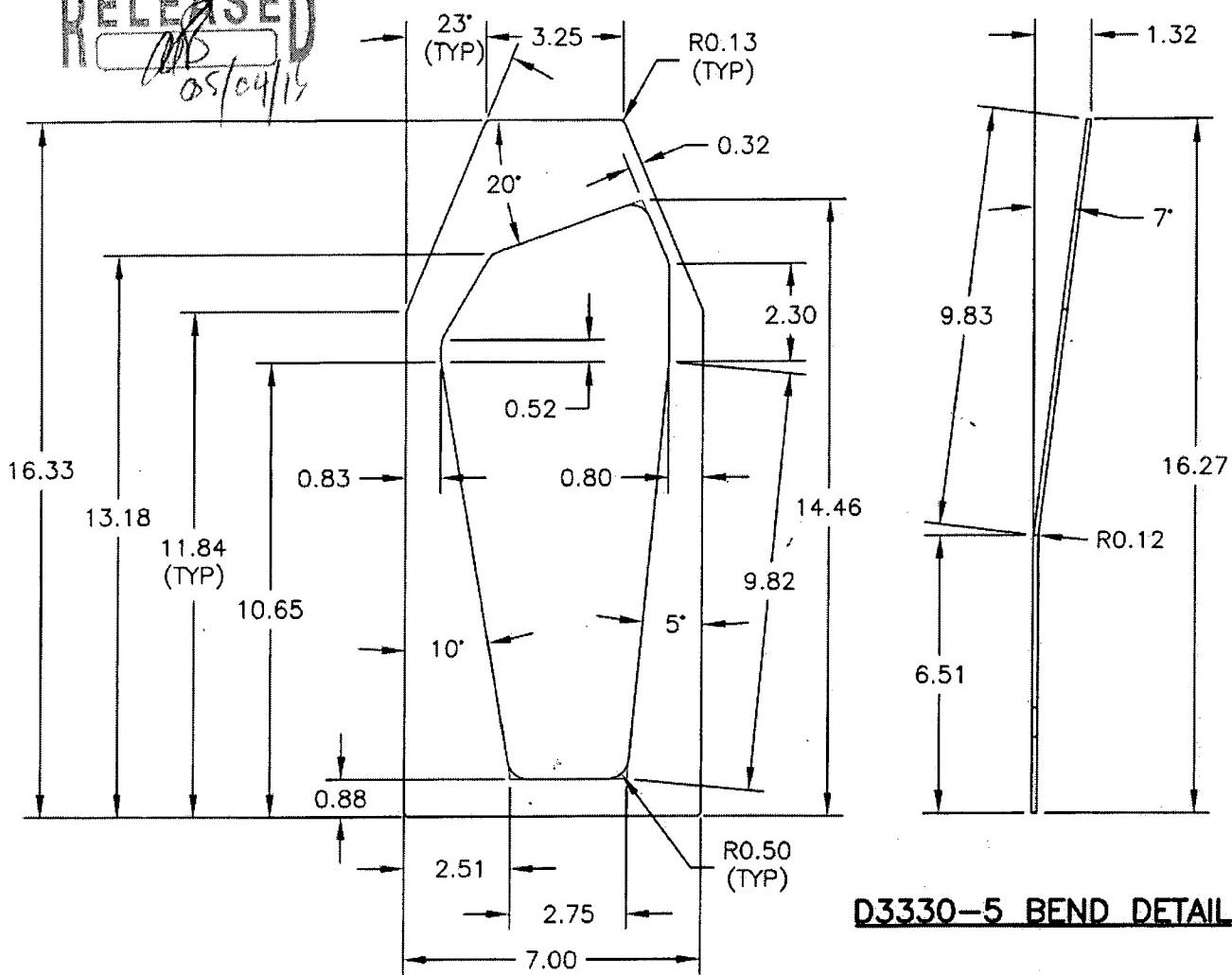
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DATE		TITLE FRAME WELDMENT

REV. B
SHEET 5 OF 9
SCALE
1:4

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MD
05/04/11



D3330-5 BEND DETAIL

FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.1250" THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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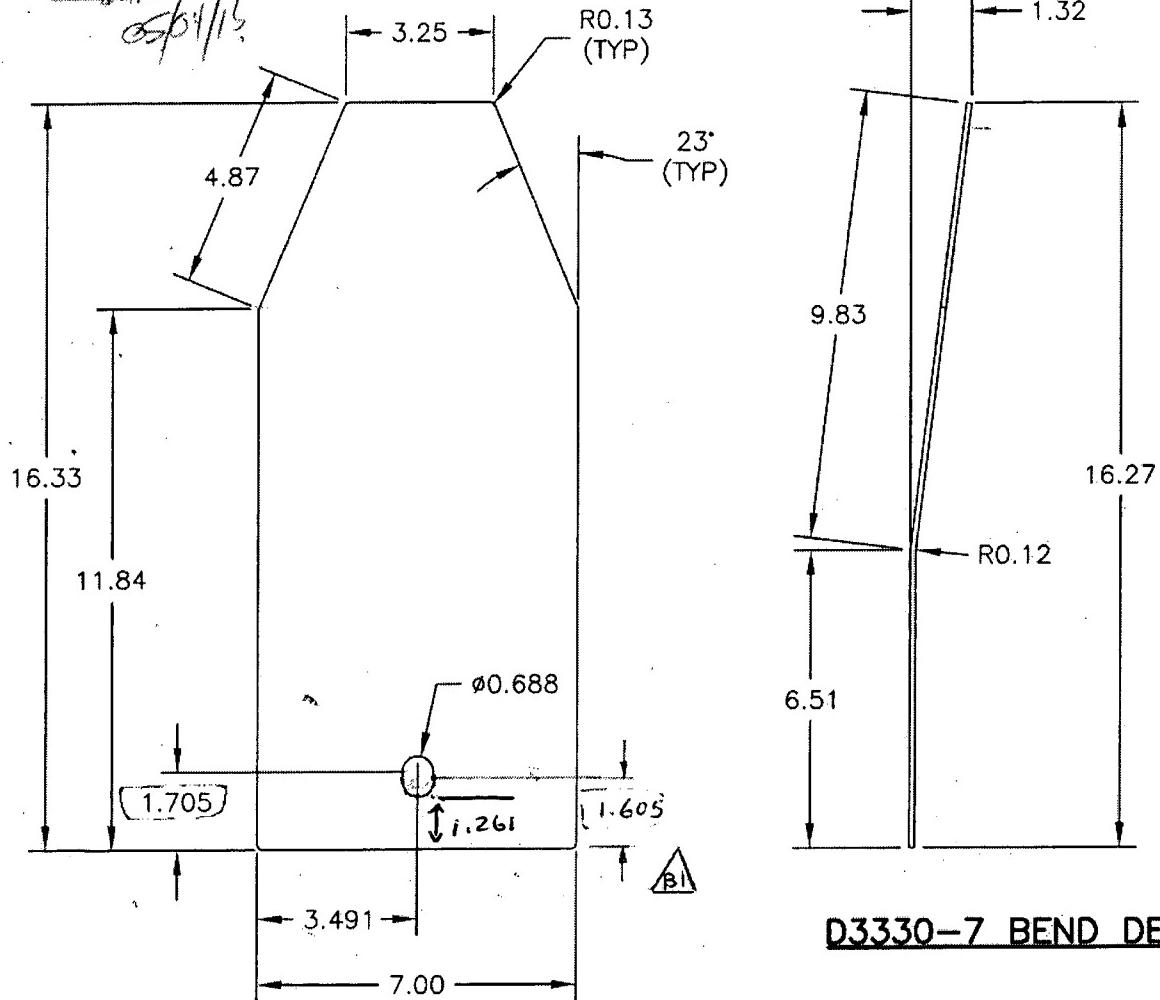
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DATE	05.02.26	D3330	SHEET 6 OF 9

RELEASED
MS/11/12**D3330-7 BEND DETAIL****FLAT PATTERN****NOTES:**

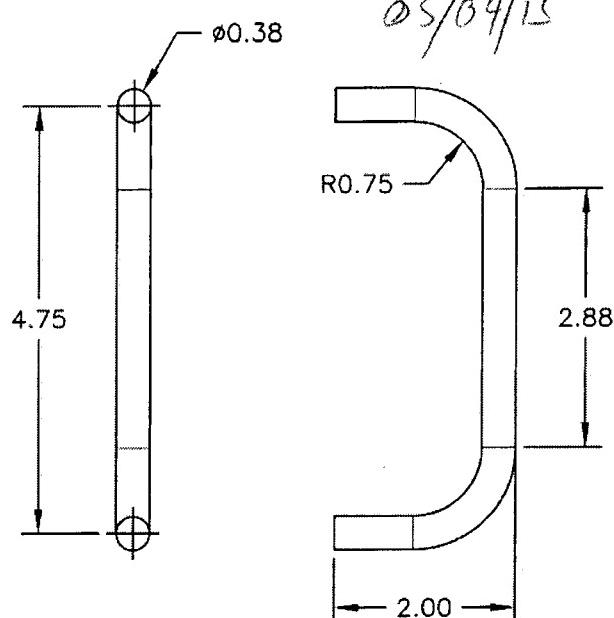
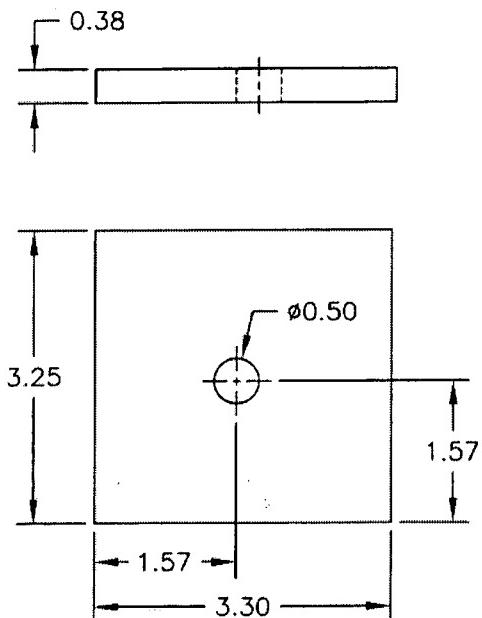
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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		D3330	SHEET 7 OF 9
DATE	TITLE	SCALE	
05.02.26	FRAME WELDMENT	1:2	



△ D3330-9 TOP PLATE

△ D3330-15 HANDLE

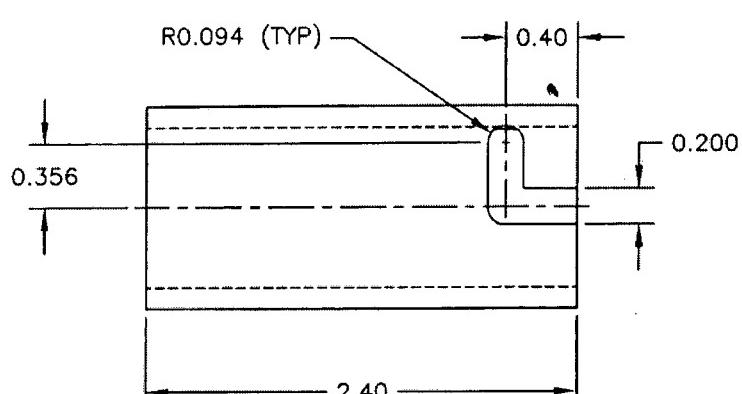
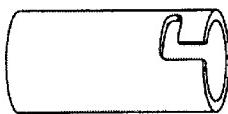
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

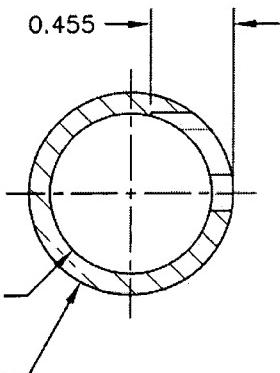
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:1

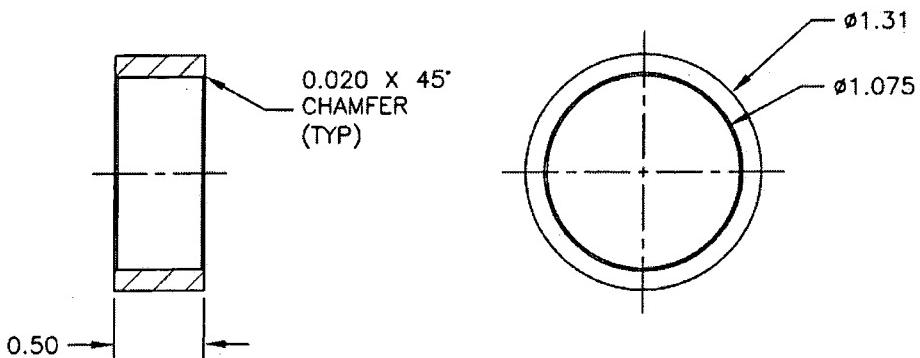


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MP 05/04/05



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

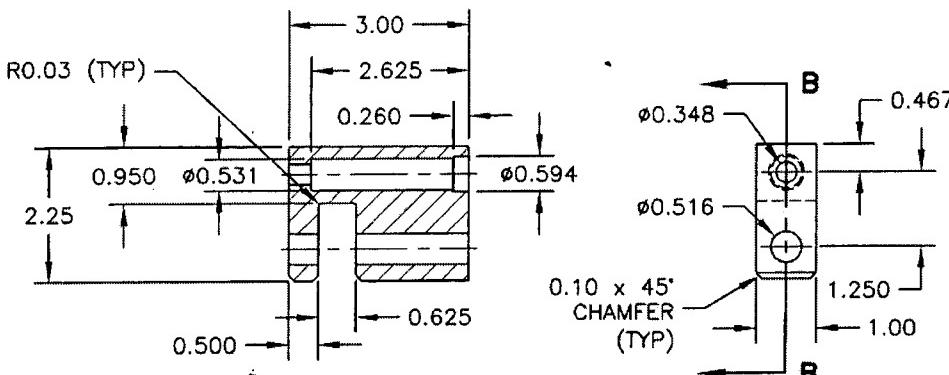
NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

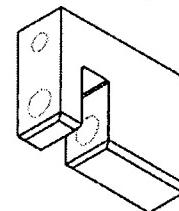
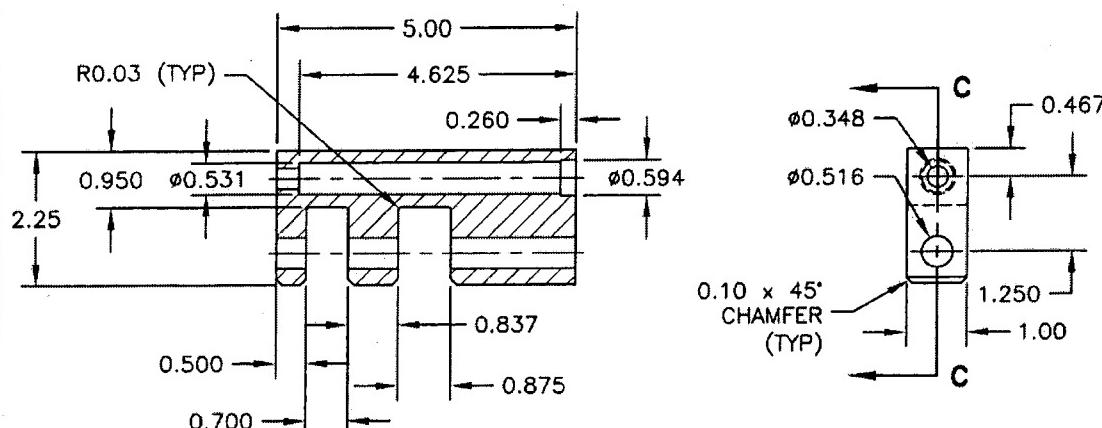
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		D3330	SHEET 9 OF 9

DATE
05.02.26TITLE
FRAME WELDMENTSCALE
1:3**SECTION B-B**

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05/04/15.

**D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL
(REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	28627
Description: PRAMU Assembly	Part Number:	3330-7
Inspection Dwg: DS330 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<i>M.M</i>	Audited by:		Prototype Approval:	
Date:	<i>06/10/04</i>	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	